

Work Order ID 75878

75878

Page 1

Thursday, November 17, 2011 4:00:18 PM

Item ID: K10112 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Skidtube 206
 Start Date: 11/1/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/9/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: 11-17 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9583	A								
K10112	B								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP FOR D206-642-112 CHG006 FOR D206-642-112 CHG002	K10112 CHG003							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

12 01 05 4
2 J Bormley 12-01-4
(4)
12/01/11 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75878***75878***

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Thursday, November 17, 2011 4:00:18 PM

Item ID: K10112

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/9/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Stop

NR2

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00				<u>11</u>	<u>12</u>	<u>01</u>	<u>05</u> (4)
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP K10112								
	PPP D206-642-111								
	PPP D206-642-111								
	Location: <u>PK</u>								
	PPP rev: <u>F</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

mf
12-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Thursday, November 17, 2011 4:00:23 PM

Work Order ID: 75878

75878

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: E00.06.14Changed GHW part # (mpp 2063)ECIPP REV:F
11.09.23 PER REV.B DD VERF:EC IPP REV:G 11.11.14
AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN5-10A
AN5-10A
Bolt

Purchased No

Each 872.0000

16

**

Location

Loc Qty

Loc Code

ST337

872

116704

11

118191

59

119547

802

Each

1,599.000

16

**

AN5-11A
AN5-11A
Bolt

Purchased No

Location

Loc Qty

Loc Code

ST337

21

117313

2

118191

19

ST518

1578

119512

1578

110

Each

1,655.000

8

32

**

AN3-41A
AN3-41A
Bolt

Purchased No

Location

Loc Qty

Loc Code

st510

1655

119042

1655

119042

12/01/08
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 75878

75878

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-6A
AN4-6A
Bolt

Purchased No

110

Each

5,062.000

12 48

**

Location

Loc Qty

Loc Code

ST356

62

119127

62

ST516

5000

119017

5000

110

Each

489.0000

1 4

**

AN4C5A
AN4C5A
BOLT

Purchased No

Location

Loc Qty

Loc Code

FP-B

49

112243

49

ST355

440

112243

340

119017

100

110

Each

511.0000

1 2 8

**

AN6-44A
AN6-44A
Bolt

Purchased No

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

504

119036

504

110

Each

1.0000

1 4

**

D206-651-041
D206-651-041
206A/B GHW

Manufactured No

Location

Loc Qty

Loc Code

FG125

1

74002

1

Thursday, November 17, 2011 4:00:23 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Thursday, November 17, 2011 4:00:23 PM

Work Order ID: 75878

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Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2652
D2652
Bushing

Manufactured No

110

Each

743.0000

16 64

**

76132

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

699

73835

579

73836

120

Manufactured No

110

Each

11.0000

{ 2 } 8

**

76802 2x

D2661-2
D2661-2
Saddle, RH Fwd Aft Out 206

Location

Loc Qty

Loc Code

MEZZ

6

10015

1

10016

1

10476

3

9913

1

ST435

5

74474

3

76517

2

76803 6x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 75878

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Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

nh *24* D2662-2
D2662-2
Saddle, RH In 206

Manufactured No

110

Each

29.0000

2

8

76 806 6x

76 807 2x

Location

Loc Qty

Loc Code

Mezz

2

11028

4

9042

3

9043

2

ST429

5

73852

2

76519

3

ST435

15

73853

15

Manufactured No

110

Each

2,551.000

10

40

nh *24* D2712
D2712
Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

2501

71160

1

73837

500

76065

2000

Manufactured No

110

Each

100.0000

2

8

76 568

76 751 6/2/01/5 4

nh *24* D2884
D2884
Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29453

10

ST025

90

73823

90

Thursday, November 17, 2011 4:00:23 PM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Thursday, November 17, 2011 4:00:23 PM

Work Order ID: 75878

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Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2885
D2885
Saddle Spacer

Manufactured No

110

Each

126.0000

2 8

**

76752

Location

Loc Qty

Loc Code

FG

10

29199

10

ST025

116

73824

116

110

Each

94.0000

1 4

**

73822

D3413-1
D3413-1
Ring

Manufactured No

Location

Loc Qty

Loc Code

ST368

2

73821

2

ST420

2

66387

1

70773

1

ST469

88

73822

88

ST473

2

71041

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Thursday, November 17, 2011 4:00:23 PM

Work Order ID: 75878

75878

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

110

Each

8,781.000

8

32

**

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2526

119075

2526

119017

MS21042L4

Purchased

No

110

Each

11,520.00

12

48

**

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

558

117441

51

117601

374

118451

133

ST516

5962

119017

5962

ST518

5000

119075

5000

119017

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Thursday, November 17, 2011 4:00:23 PM

Work Order ID: 75878

75878

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L6

Purchased

No

110

Each

1,484.000

2

8

MS21042L6

**

Nut

Location

Loc Qty

Loc Code

ST300

484

117677

25

118384

5

118927

48

118968

406

ST518

1000

119075

1000

118968

NAS1149C0463R

Purchased

No

110

Each

1,379.000

1

4

NAS1149C0463R

**

Washer

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1378

117735

378

119097

1000

117735

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Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Thursday, November 17, 2011 4:00:23 PM

Work Order ID: 75878

75878

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

110

Each

4,466.000

8

32

**

119537

[Signature]

NAS1149D0363.I

Washer

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1450

117601

148

118077

1

118612

55

118968

1246

110

Each

12,710.00

24

96

**

[Signature]
12/01/05

(9)

NAS1149D0463J

Purchased

No

110

Each

12,710.00

24

96

**

NAS1149D0463.I

Washer

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12386

119075

10000

119097

2386

119075

Thursday, November 17, 2011 4:00:23 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Thursday, November 17, 2011 4:00:23 PM

Work Order ID: 75878

75878

Parent Item: K10112

K10112

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

W *4* NAS1149D0563J Purchased No
NAS1149D0563.I
 Washer

110 Each 5,153.000 8 32

**

C

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3153

118206

2153

118614

1000

118206

W *4* NAS1149D0663J Purchased No
NAS1149D0663.I
 Washer

110 Each 2,598.000 4 16

**

12/01/11

Location

Loc Qty

Loc Code

ST407

2598

119075

2598

119075

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-642

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4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY -113	QTY -114	QTY -151	QTY -149	PART NUMBER	DESCRIPTION
	X				D206-642-113	SKIDTUBE INSTALLATION, LH
		X			D206-642-114	SKIDTUBE INSTALLATION, RH
	1	1	X		D206-642-151	SKIDTUBE
				X	D206-642-149	RUN-ON LANDING WEARPLATE KIT
	1	1			D206-651-041	* 206 GHW ADAPTER ⁽²⁾
1					D3804-041	SKIDTUBE ASSEMBLY
2A			6		D2651-1	* PLUG ⁽¹⁾
2B			6		D2651-3	* O-RING ⁽¹⁾
3			1		D2646	* AFT CAP ⁽¹⁾
4			2		MS27039-1-08	* SCREW ⁽¹⁾
5			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1				D2661-1	SADDLE, FWD OUT, LH
6		1			D2661-2	SADDLE, FWD OUT, RH
7	1				D2662-1	SADDLE, FWD IN, LH
7		1			D2662-2	SADDLE, FWD IN, RH
8	1				D2661-1	SADDLE, AFT OUT, LH
8		1			D2661-2	SADDLE, AFT OUT, RH
9	1				D2662-1	SADDLE, AFT IN, LH
9		1			D2662-2	SADDLE, AFT IN, RH
10	8	8			AN3-41A	BOLT
11	16	16			D2652	BUSHING
12A	8	8			MS21042-3	NUT (OR MS21042L3)
12B	8	8			NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4			AN5-7A	BOLT
14	4	4			AN5-7A	BOLT
15	8	8			NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12			AN4-6A	BOLT
17	24	24			NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12			MS21042-4	NUT (OR MS21042L4)
20A			1	1	D3805-041	FWD WEARPLATE ASSY
21A			1	1	D3807-1	* GASKET ⁽³⁾
22A			1	1	D3805-045	AFT WEARPLATE ASSY
23A			1	1	D3807-5	* GASKET ⁽⁴⁾
26A			7	7	AN3-36A	BOLT
26B			7	7	NAS1149D0363J	WASHER (OR AN960JD10)
26C			7	7	MS21042-3	NUT (OR MS21042L3)
26D			14	14	D3873-1	BUSHING
27				2	D2649	SPACER
28	2	2			AN6-44A	BOLT
29A	2	2			MS21042-6	NUT (OR MS21042L6)
29B	4	4			NAS1149D0663J	WASHER (OR AN960JD616)
34	1	1			AN4C5A	BOLT
35	1	1			NAS1149C0463R	WASHER (OR AN960C416)
36	1	1			D3413-1	RING
37	10	10			D2712	SET SCREW
38	2	2			D2884	SPACER
39	2	2			D2885	SPACER

- NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D3804-041 ASSEMBLY ABOVE
⁽²⁾ NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS
⁽³⁾ DENOTES THAT PART IS INCLUDED WITH D3805-041 ASSEMBLY ABOVE
⁽⁴⁾ DENOTES THAT PART IS INCLUDED WITH D3805-045 ASSEMBLY ABOVE

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Revision: 0
Date: 11.06.15

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. O AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 4

REF FAA STC: SA00475SE

REF CANADIAN STC: SH98-4

REF EASA STC: EASA.IM.R.S.01320

PROCEDURE:

FOR D206-642-113/-114 SKIDTUBE INSTALLATION KITS, IT HAS BEEN DETERMINED THAT AN5-10A (FWD) AND AN5-11A (AFT) BOLTS ARE MORE APPROPRIATE BOLT LENGTHS FOR ATTACHING THE SKIDTUBES TO THE CROSSTUBES THAN THE AN5-7A BOLTS PREVIOUSLY PROVIDED IN THE KITS.

4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

32.12 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY. -113	QTY. -114	PART NUMBER	DESCRIPTION
			D206-642-113	SKIDTUBE INSTALLATION, LH
			D206-642-114	SKIDTUBE INSTALLATION, RH

IS:

13	4	4	AN5-10A	BOLT
14	4	4	AN5-11A	BOLT

WAS:

13	4	4	AN5-7A	BOLT
14	4	4	AN5-7A	BOLT

FOR FURTHER DETAILS REFER TO PAGE 22, DETAIL A OF IIN-D206-642 REV. O, OR PAGE 30, DETAIL A OF ICA-D206-642 REV. 4.

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